











DIMENSIONING AND TOLERANCING PER ASME Y14.5M (USD STANDARDS). THIS DRAWING IS A CONTROLLED DOCUMENT.

PART NUMBER	REV	FIRST USED	TERMINALS APPLIED
1852892-1	A	AOM / CLS	520971, 521583, 1969109, 1969283 521282, 521716, 521347
1852892-2	A	K UNIT	
1852892-3	A	G UNIT	
1852892-4	A	AOM / CLS	521087 
1852892-5	A	K UNIT	
1852892-6	A	G UNIT	
1852892-7	A	KOMAX	
7-1852892-7	A	SPARE PARTS KIT 	

CRIMPING DATA				
PAD LETTER	CRIMP HEIGHT	WIRE SIZE	STRIP LENGTH	
A	.070	#14	.281	
B	.061	#16		
C	.055	#18		
D	NOT	USED	-	
CRIMP	SIZE	TYPE	FEED	TERM APPL SPEC
WIRE	.110	F	.740	114-2124
INSUL	.180	0		
INSUL RANGE	WIRE RANGE	APPLICATOR INSTRUCTION SHEET		
.110-.160	18 -14	AI 8099 AI 8102		

-  RECOMMENDED SPARE PARTS.
-  ITEMS NOT SHOWN ON ASSEMBLY.
-  TOLERANCE ON CUT LENGTH TO BE ±.13.
-  USED ON THE CLS I AND II MACHINES ONLY. REMOVE THE TWO MOUNTING SCREWS SECURING THE PRODUCT DEREELEER AND PLACE THE PRODUCT GUIDE (ITEM 111) ON TOP OF THE MOUNTING BRACKET. REASSEMBLE AND RETIGHTEN THE TWO MOUNTING SCREWS.
-  ITEM 127 "T" TERMINATING UNIT CONVERSION KIT 856399-1 CONVERTS APPLICATOR 852500-2 TO A 852500-1.
-  ITEM 128 AOM 4A FEED SIDE CONVERSION KIT 856875-1 CONVERTS AN AOM TO RUN APPLICATOR 852500-1.
-  ITEM 129 "K" TERMINATING UNIT CONVERSION KIT 856398-1 CONVERTS APPLICATOR 852500-1 TO A 852500-2.
-  ADJUSTING THE VALVES (ITEMS 40 AND 47).

8a. FOR 852500-1 ASSEMBLY ONLY.

MAKE SURE THE CAM VALVE (ITEM 84) IS IN THE FULLY DOWN POSITION BEFORE PLACING THE RAM BACK INTO THE APPLICATOR. INSTALL THE APPLICATOR INTO A "T" TERMINATING UNIT, TURNING THE POWER TO THE UNIT OFF WHILE ALLOWING THE AIR TO REMAIN ON. MANUALLY CYCLE THE UNIT, PRODUCT MUST NOT BE PRESENT IN THE APPLICATOR, SO THAT THE RAM IS AT DEAD BOTTOM OF ITS STROKE. LOOSEN THE FOUR SCREWS SECURING THE VALVES (ITEMS 40 AND 47) AND SLOWLY RAISE THE RAM UPWARD UNTIL THE INSULATION CRIMPER LEG (ITEM 78) IS IN THE CENTER OF THE INSERTER (ITEM 18). ADJUST THE LOWER VALVE (ITEM 47) SO IT IS ON THE LOWER LOBE OF THE CAM VALVE (ITEM 84) AND IS ACTUATED, THEN RETIGHTEN THE TWO MOUNTING SCREWS. THIS VALVE WILL CAUSE THE INSERTION CYLINDER TO EXTEND, INSERTING THE HOUSING ONTO THE TERMINATED PRODUCT.

CONTINUE RAISING THE RAM, STOPPING JUST BEFORE TOP DEAD CENTER. NOW POSITION THE UPPER VALVE (ITEM 40) SO IT IS ON THE UPPER LOBE OF THE VALVE CAM (ITEM 84) AND IS ACTUATED, THEN RETIGHTEN THE TWO MOUNTING SCREWS. THIS VALVE WILL CAUSE THE INSERTION CLYINDER TO RETRACT AFTER THE HOUSING IS APPLIED. COMPLETE THE THE UNIT CYCLE TO TOP DEAD CENTER.

CHECK THE ADJUSTMENTS JUST MADE BY PUTTING PRODUCT INTO THE APPLICATOR AND CYCLING THE UNIT UNDER POWER A FEW TIMES AND VERIFY THAT THE CURRENT SETTINGS ARE CORRECT. IF ADJUSTMENTS MUST BE MADE TURN OFF POWER TO THE UNIT, REMOVE ANY PRODUCT AND FOLLOW THE STEPS ABOVE.

NOTE: UNDER MANUAL MODE DAMAGE TO THE HOUSINGS WILL OCCUR WHEN PRODUCT IS APPLIED TO THE APPLICATOR DUE TO TIMING, THIS IS AN ENGINEERED INTERFERENCE AND WILL BE CORRECTED UNDER POWER OF THE UNIT.







8b. FOR 852500-2 ASSEMBLY ONLY.

MAKE SURE THE CAM VALVE (ITEM 84) IS IN THE FULLY UP POSITION BEFORE PLACING THE RAM BACK INTO THE APPLICATOR. INSTALL THE APPLICATOR INTO A "K" TERMINATING UNIT, TURNING THE POWER TO THE UNIT OFF WHILE ALLOWING THE AIR TO REMAIN ON. MANUALLY CYCLE THE UNIT, PRODUCT MAY BE PRESENT IN THE APPLICATOR, SO THAT THE RAM IS AT DEAD BOTTOM OF ITS STROKE. LOOSEN THE FOUR SCREWS SECURING THE VALVES (ITEMS 40 AND 47) AND SLOWLY RAISE THE RAM UPWARD UNTIL THE INSULATION CRIMPER LEG (ITEM 78) CLEARS THE INSERTER BY .03±.03. ADJUST THE LOWER VALVE (ITEM 47) SO IT IS ON THE LOWER LOBE OF THE CAM VALVE (ITEM 84) AND IS ACTUATED, THEN RETIGHTEN THE TWO MOUNTING SCREWS. THIS VALVE WILL CAUSE THE INSERTION CYLINDER TO EXTEND, INSERTING THE HOUSING ONTO THE TERMINATED PRODUCT.

CONTINUE RAISING THE RAM, STOPPING JUST BEFORE TOP DEAD CENTER. NOW POSITION THE UPPER VALVE (ITEM 40) SO IT IS ON THE UPPER LOBE OF THE VALVE CAM (ITEM 84) AND IS ACTUATED, THEN RETIGHTEN THE TWO MOUNTING SCREWS. THIS VALVE WILL CAUSE THE INSERTION INSERTION CYLINDER TO RETRACT AFTER THE HOUSING IS APPLIED. COMPLETE THE THE UNIT CYCLE TO TOP DEAD CENTER.


CHECK THE ADJUSTMENTS WITH A FEW MANUAL CYCLES OF THE PRESS TO VARIIFY CLEARANCES FOR THE TOOLING AND CONTINUING TO ADJUST THE VALVES UNTIL THESE CLEARANCES ARE OBTAINED.


-  THE CYLINDER MOUNT (ITEM 31) SHOULD BE ADJUSTED VERTICALLY SO THE INCOMING PRODUCT GOES THROUGH THE STRIP GUIDES (ITEMS 60 AND 95) AND INTO THE INSERTER (ITEM 18) WITHOUT ANY OBSTRUCTIONS TO DISLodge OR STUB ON THE HOUSINGS.

-  LOCATE THE REAR KEYS THAT LOCATE THE APPLICATOR TO THE TERMINATING UNIT BASE PLATE. THE SOCKET HEAD CAP SCREW SECURING THE KEY CLOSEST TO THE FRONT OF THE UNIT MUST BE REPLACED WITH A BUTTON HEAD CAP SCREW (ITEM 92 OR 107). THIS CHANGE WILL NOT EFFECT ANY OTHER APPLICATOR.
-  BUTTON HEAD CAP SCREW (ITEM 92 OR 107) IS TO BE BAGGED AND SHIPPED ALONG WITH THE APPLICATOR.
-  TERMINAL 521087 REQUIRES LUBRICATOR ASSY.
-  ADD SHIM BETWEEN POD INSERTER & HOUSING IF TERMINALS HIT POD INSERTER.
- 14. SPRING LOADED TONKER (P/N 354853-1) MUST BE USED WHEN RUNNING THE APPLICATOR ON A LEADMAKER.
-  AIR VALVE CONVERSION KIT, KOMAX 1633069-1 CONVERTS 852500-1 UP TO & INCLUDING REV N TO A 852500-7. AIR VALVE CONVERSION KIT, KOMAX 1633069-2 CONVERTS 852500-1 REV P THRU CURRENT TO A 852500-7.
-  GRIND BOTTOM OF ITEM 46 IF IT PROTRUDES BELOW BOTTOM OF ITEM 95.

LOC A  
DIST 66

P	LTR	REVISION RECORD	DATE	DWN	APVD

DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:	
0 PLC	± .-	1 PLC	± .-
1 PLC	± .-	2 PLC	± .-
2 PLC	± .-	3 PLC	± .-
3 PLC	± .-	4 PLC	± .-
ANGLES: -		SURFACE TEXTURE: 	

DWN	M.YOUNGER	05OCT2012	MATERIAL	-	HEAT TREAT	-
CHK	T. ELBIN	05OCT2012	 TE Connectivity			
APVD	T. ELBIN	05OCT2012				
NAME: ULTRA POD FLAG APPLICATOR						
SCALE	1:1	SIZE	A1	DRAWING NO	1852892	
SHEET	1	OF	3	REV	A	

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

DIMENSIONING AND TOLERANCING PER ASME Y14.5M (ISO STANDARDS). THIS DRAWING IS A CONTROLLED DOCUMENT.

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LOC A DIST 66

Table with columns for QTY REQD PER ASSY, PART NO, DESCRIPTION, ITEM NO. Includes parts like CONNECTOR, TUBING, MALE; VALVE, FLOW CONTROL; AIR LINE KIT .250 TO 4MM; LUBRICATOR ASSY; INSERT, GUARD; K TERM. UNIT CONV. KIT; HOSE, FLEXIBLE .250 OD; TUBE, PLASTIC .250 OD; POST, RAM; PLATE, IDENTIFICATION; SCR., DRIVE #2 X .19 LG; VALVE ASSEMBLY; GUIDE, PRODUCT; BRACKET, PNEUMATIC MOUNTING; VALVE, QUICK EXHAUST 1/8NPT; SCR., BHC 8-32UNF X .50 LG; GUARD ASSEMBLY; BUSHING, PIPE, FITTING 1/4NPT; TEE, PIPE, FITTING 1/4NPT; FILTER, MINATURE 1/4NPT; NIPPLE, CLOSE 1/4NPT; LUBRICATOR 1/4NPT; BODY, QUICK CONNECT; SCR., SET, SOC 4-40UNC X .25 LG; CONN., TUBING, MALE 1/8NPT-1/4 TUBE; GUIDE, REAR STRIP; SCR., SET, SOC FT. PT. 8-32UNC X .25 LG; SPRING, COMP. .120 DIA X .63 LG; STRIPPER, HOUSING; SHEAR, REAR; SPACER, LEFT SHEAR; WASHER, RAM; WASHER, LAMINATED; BLADE, SLUG; SCR., SHC 8-32UNC X .38 LG; VALVE, CAM; DISC, INSULATION; DISC, WIRE CRIMP ADJ.; SPACER, CRIMPER; SPRING, COMP. .300 DIA X 1.25 LG; PIN, DOWEL .312 DIA X .50 LG; CRIMPER, INSULATION; CRIMPER, WIRE; SCR., SET, SOC 1/4-20UNC X .25 LG; SCR., SET, SOC 6-32UNC X .25 LG; SPRING, COMP.; SPRING, ASSIST; BALL, STEEL.

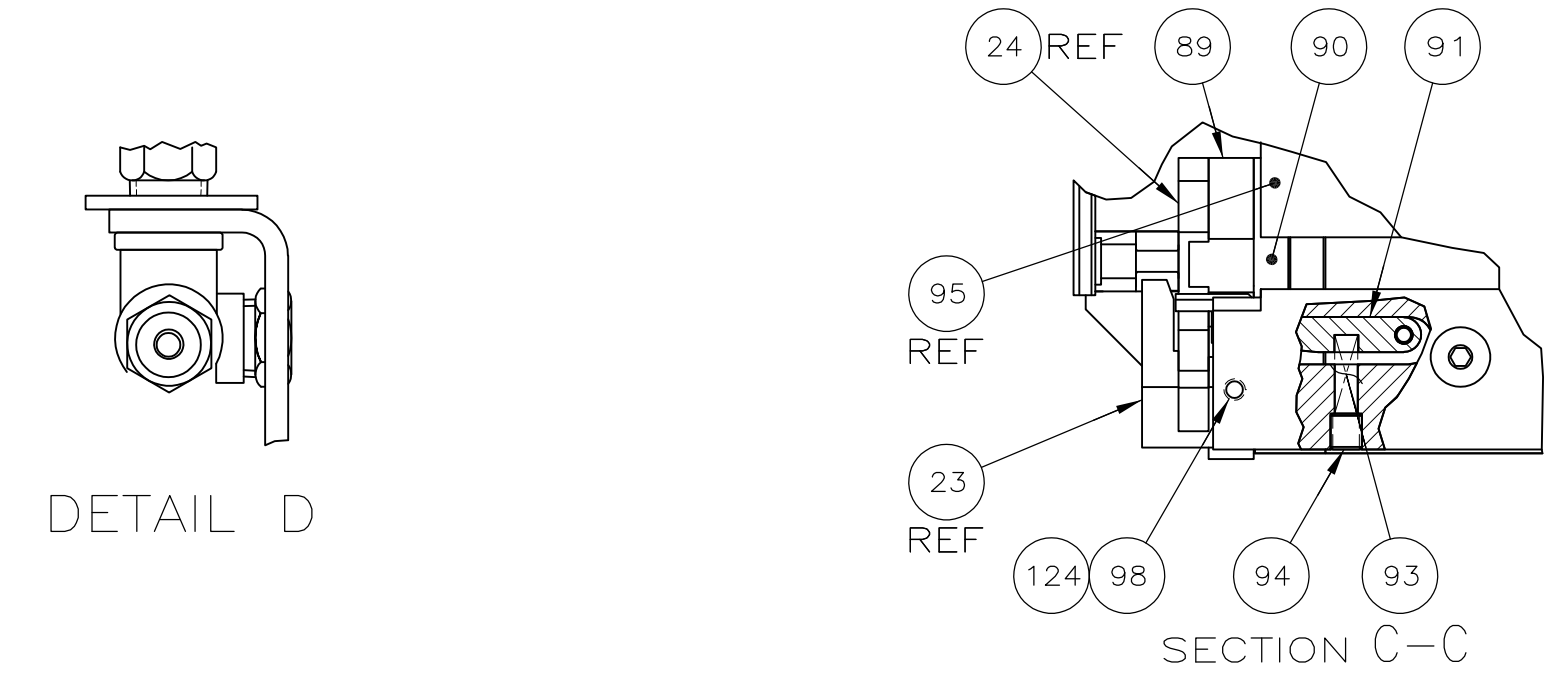
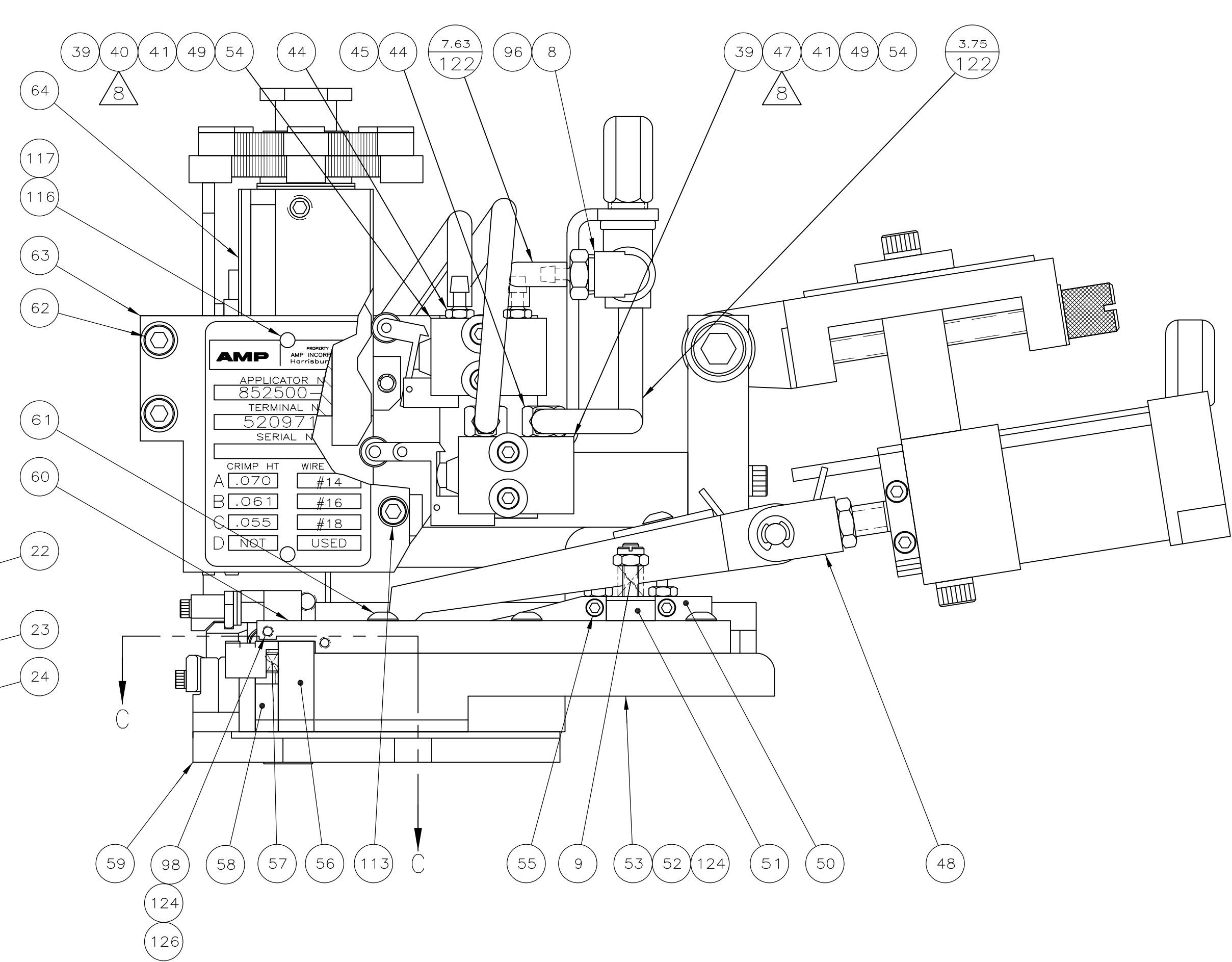
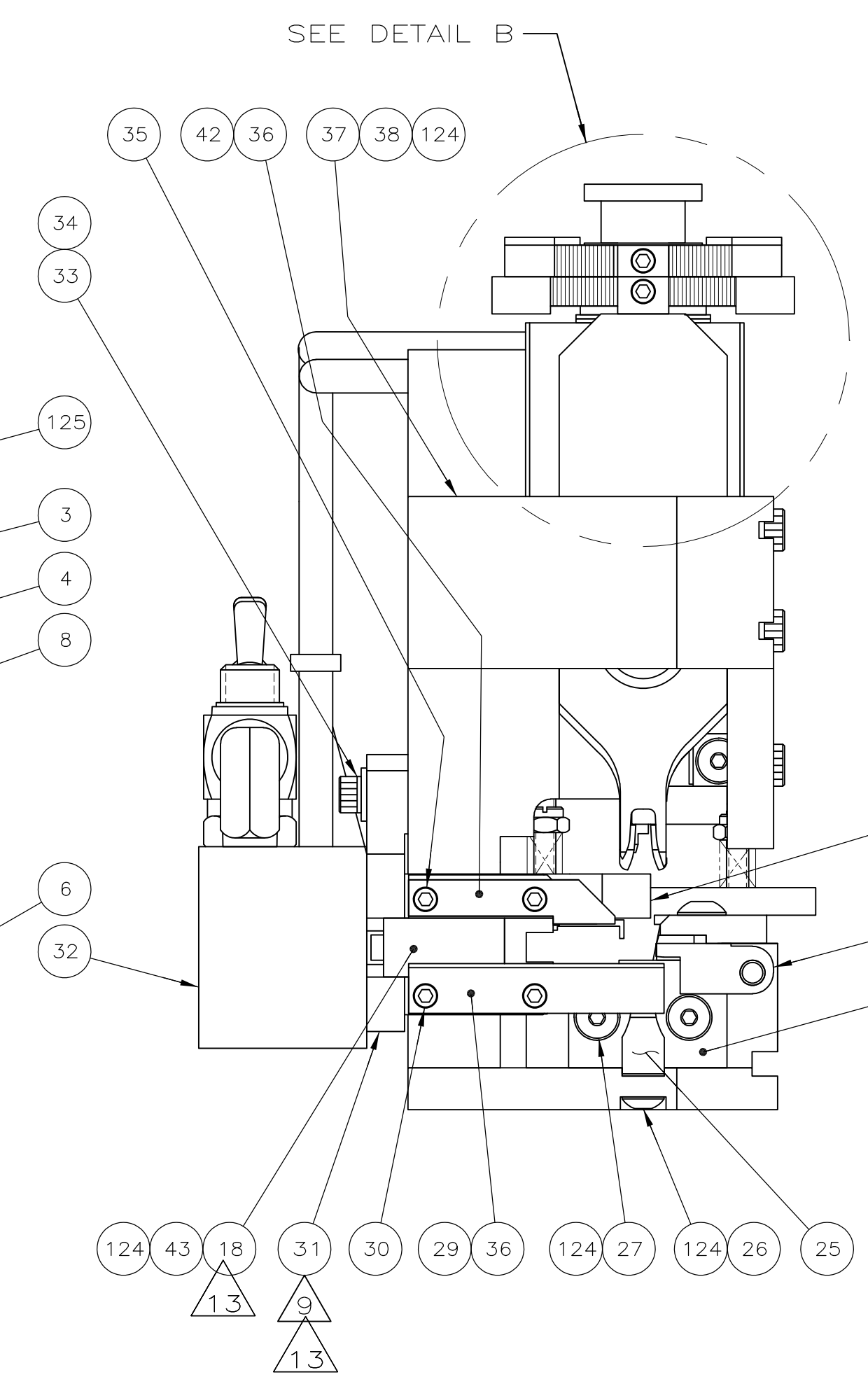
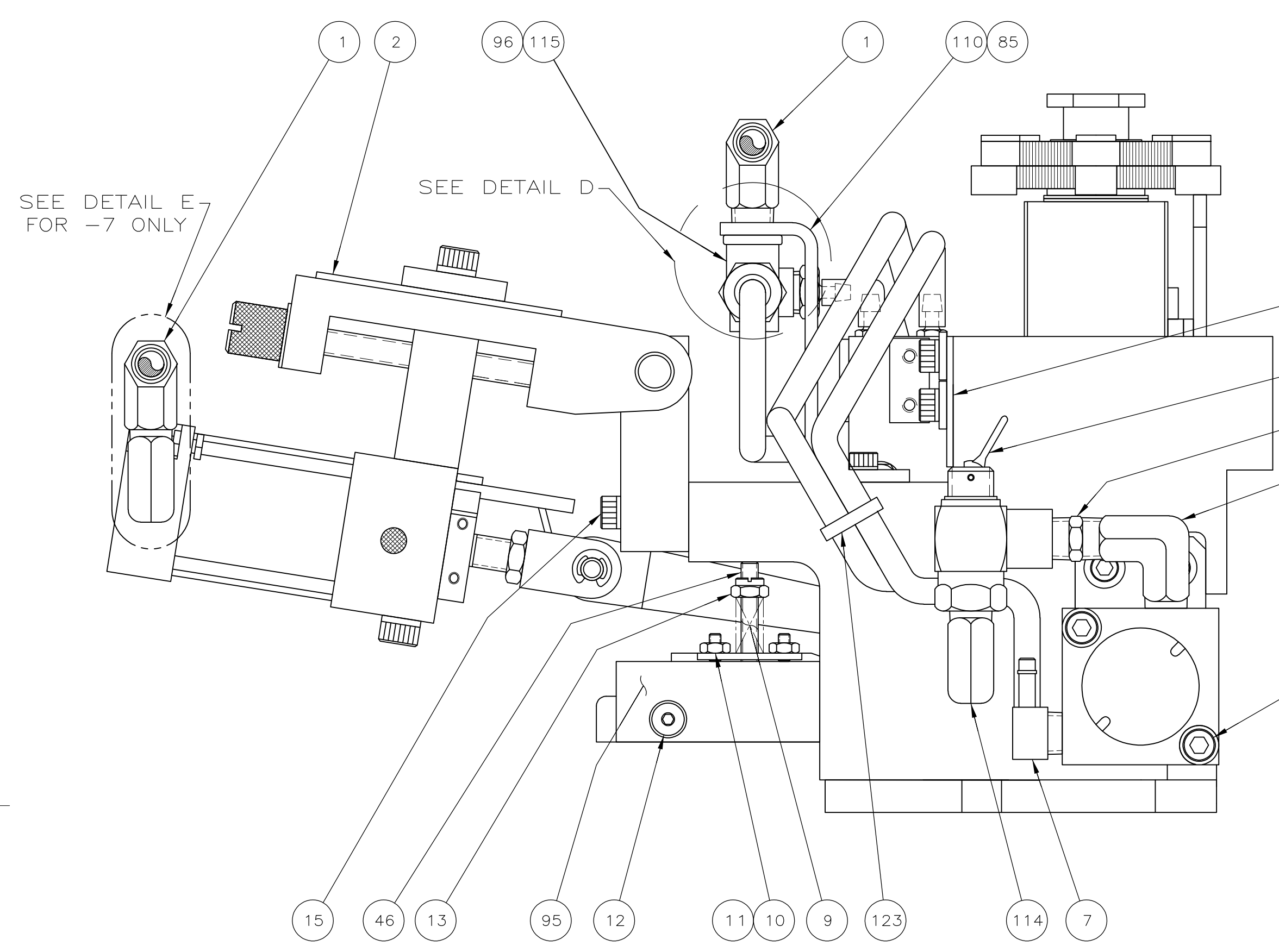
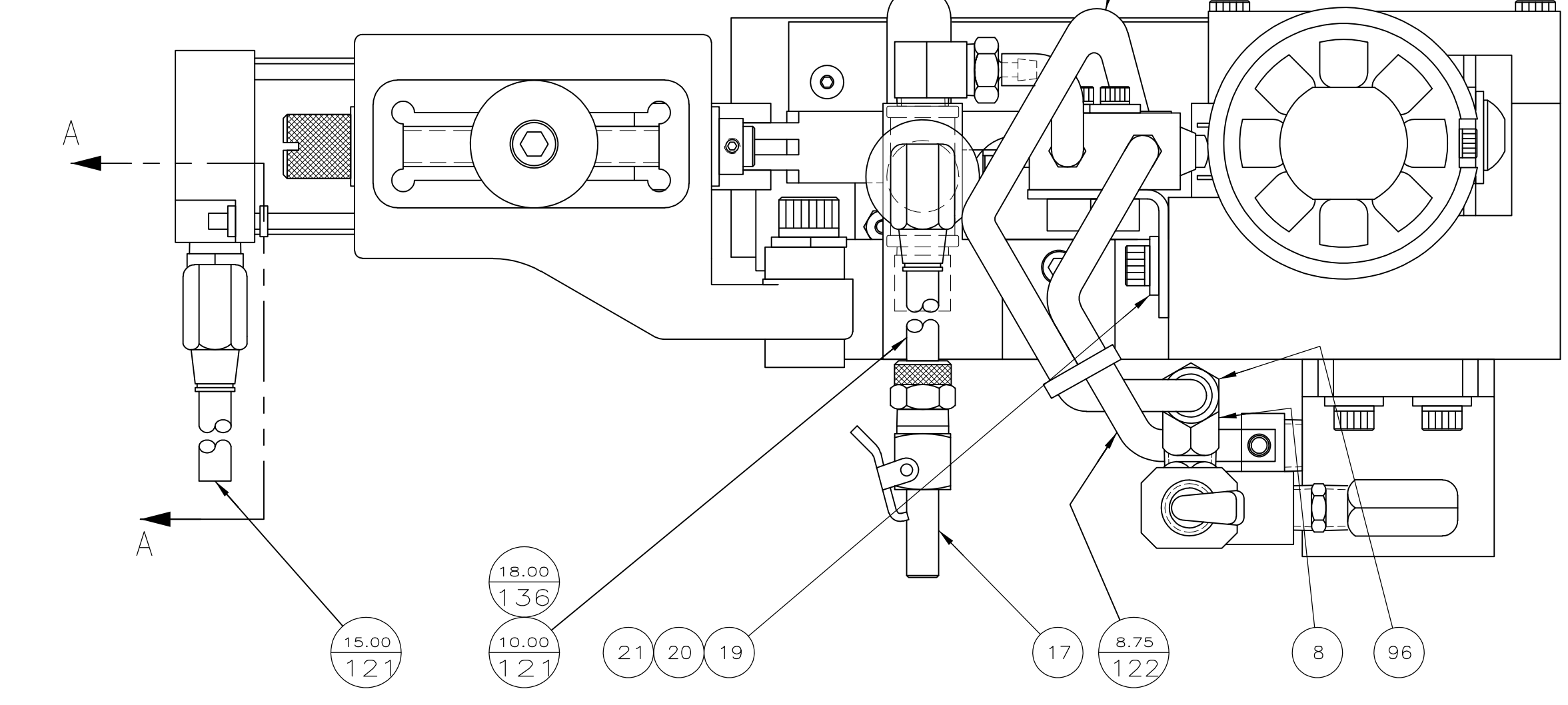
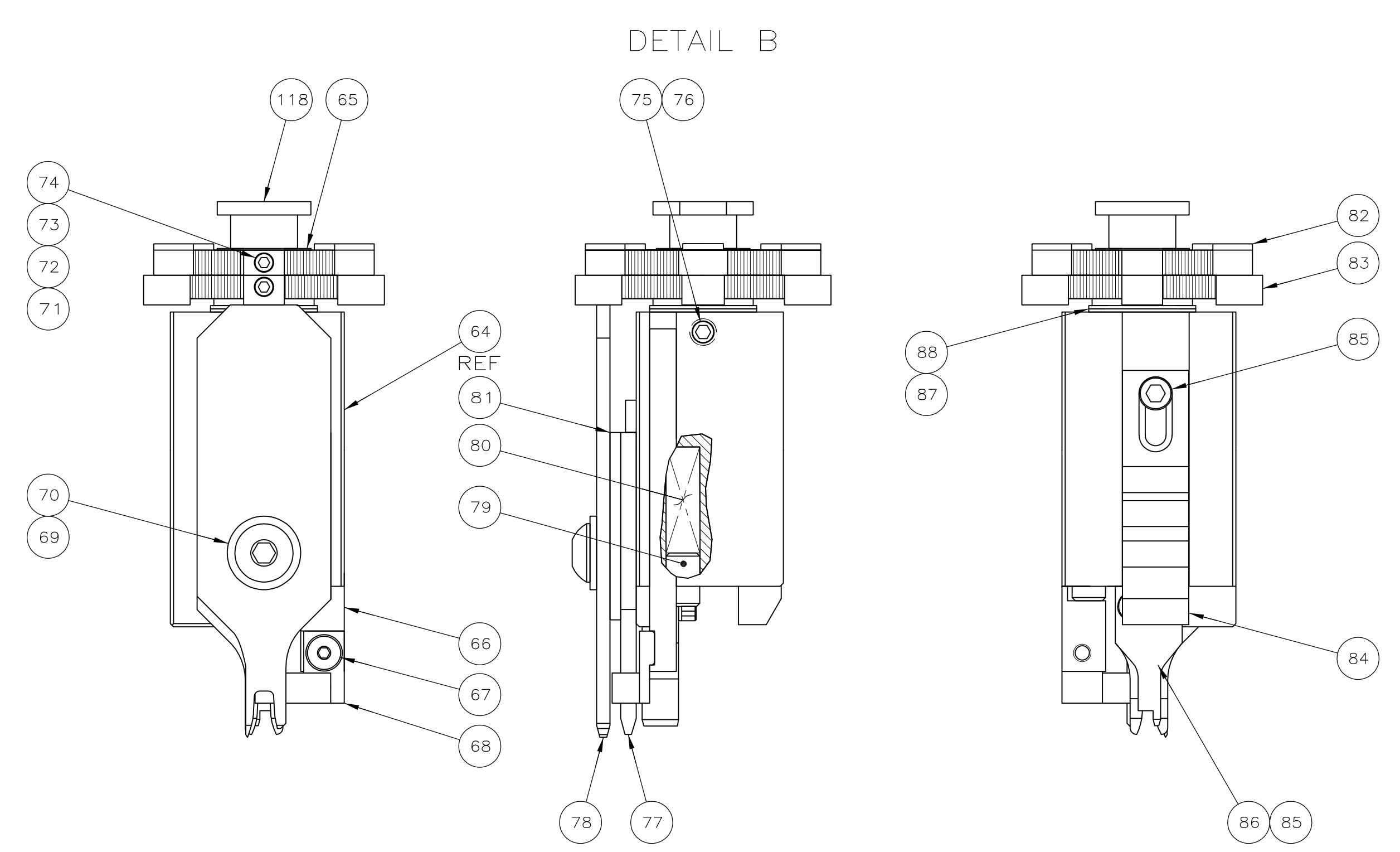
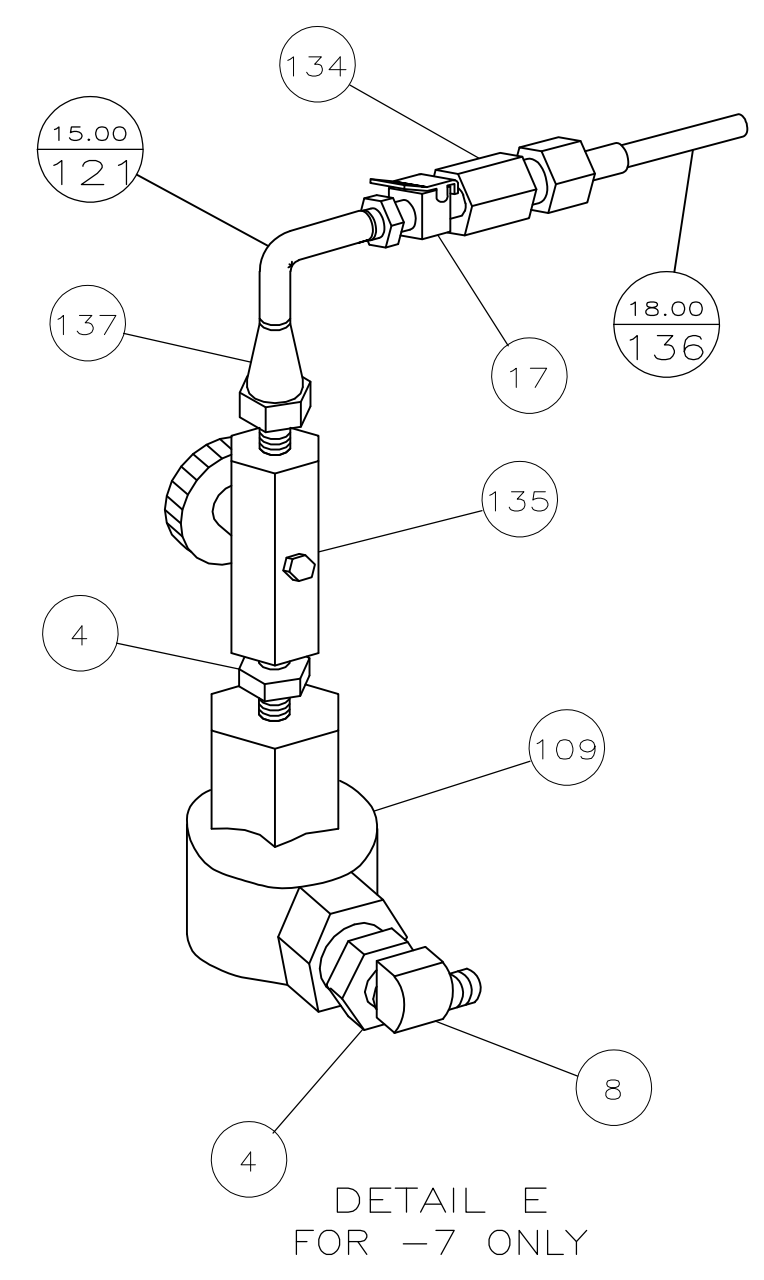
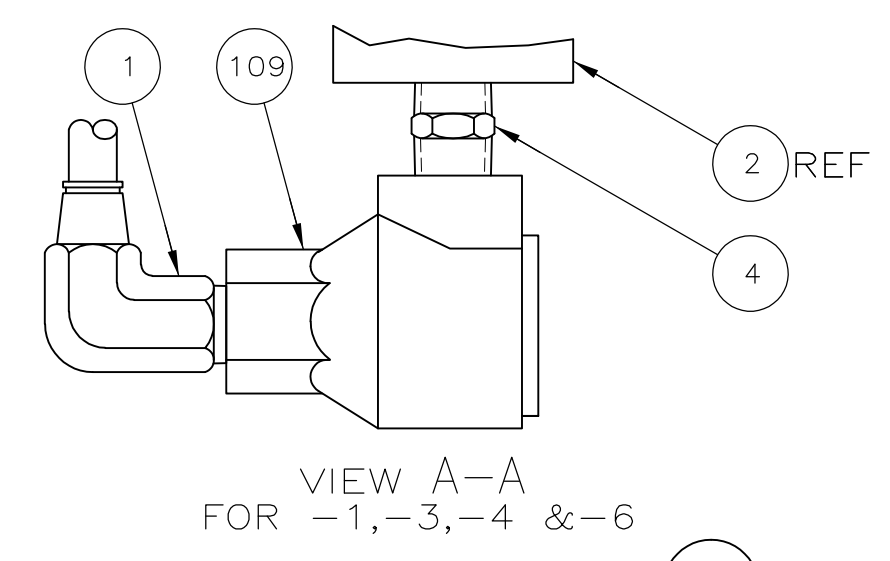
Table with columns for QTY REQD PER ASSY, PART NO, DESCRIPTION, ITEM NO. Includes parts like SCR., BHC 5/16-24UNF X 1.00 LG; BLOCK, CRIMPER SPACER; STRIPPER; SCR., BHC 6-32UNC X .25 LG; SLIDE, STRIPPER; WASHER, WAVE SPRING; RAM; CAP, RAM; SCR., SHC 10-32UNF X 1.00 LG; SCR., BHC 8-32UNC X .50 LG; GUIDE, FRONT STRIP; PLATE, BASE; SPACER, RIGHT SHEAR; SPRING, TORSION; PLATE, BACK-UP PIVOT; SCR., SHC 4-40UNC X .25 LG; WASHER, LOC 6; PLATE, STRIP GUIDE; SCR., BHC 1/4-20UNC X .50 LG; ARM, STOCK DRAG; DRAG, STOCK; WASHER, FLAT 6; FEED FINGER ASSEMBLY; VALVE, LEVER ROLLER; STUD 8-32UNC X 1.00 LG; ELBOW, TUBE TO MALE 10-32NPT; CONN., MALE TUBE TO MALE THD 10-32NPT; SCR., SHC 10-24UNC X .63 LG; HOLD-DOWN, HOUSING; PLATE, NUT; VALVE, LEVER ROLLER; SCR., SHC 6-32UNC X 1.00 LG; SCR., BHC 1/4-20UNC X .63 LG; HOUSING, APPLICATOR; PLATE, TOP RETAINER; SCR., SHC 4-40UNC X .75 LG; SCR., SHC 8-32UNC X .75 LG; WASHER, FLAT 8; CYL., AIR, DOUBLE ACTING 1/8NPT; MOUNT, CYLINDER; SCR., BHC 4-40UNC X .62 LG; LEAD-IN, HOUSING; SCR., BHC 8-32UNC X 1.00 LG; SCR., BHC 8-32UNC X .38 LG; ANVIL; SHEAR, FRONT; BACK-UP, TERMINAL; STOP, WIRE; SCR., SHC 10-32UNF X .38 LG; WASHER, FLAT 10; BRACKET, VALVE; INSERTER; INSERT, COUPLING; SCR., SHC 10-32UNF X 1.00 LG; NUT, FLEX 8-32UNC; SCR., BHC 6-32UNC X .50 LG; SCR., SET, SOC CONE PT 4-40UNC X .38 LG; NUT, HEX 4-40UNC; SPRING, COMP. .300 DIA X .44 LG; ELBOW, MALE 1/8NPT; ELBOW, TUBING MALE 1/8NPT-1/4 TUBE; SCR., SHC 10-32UNF X 1.25 LG; NIPPLE, HEX PIPE 1/8NPT; VALVE, TOGGLE 1/8NPT; AIR FEED ASSEMBLY; CONN., TUBING, MALE 1/8NPT-1/4 TUBE.

Table with columns for DIMENSIONS (INCHES), TOLERANCES UNLESS OTHERWISE SPECIFIED, ANGLE(S), SURFACE TEXTURE.

Table with columns for DIMENSIONS (INCHES), TOLERANCES UNLESS OTHERWISE SPECIFIED, ANGLE(S), SURFACE TEXTURE.

Table with columns for DWG (M.YOUNGER), CHK (T. ELBIN), APVD (T. ELBIN), NAME (ULTRA POD FLAG APPLICATOR), SCALE (1:1), SIZE (A1), DRAWING NO (1852892), SHEET (2 of 3), REV (A).

DIMENSIONING AND TOLERANCING PER ASME Y14.5M (USD STANDARDS). THIS DRAWING IS A CONTROLLED DOCUMENT. P/N 1852892



AMP  
APPLICATOR N  
852500  
TERMINAL N  
52097  
SERIAL N

CRIMP HT	WIRE
A .070	#14
B .061	#16
C .055	#18
D NPT	USED

LOC A  
DIST 66

DIMENSIONS: INCHES		TOLERANCES UNLESS OTHERWISE SPECIFIED:										
0	PLC	±	-									
1	PLC	±	-									
2	PLC	±	-									
3	PLC	±	-									
4	PLC	±	-									
ANGLES: SURFACE TEXTURE		✓										
- SEE SHEET 1		-										
P	LTR	REVISION RECORD	DATE	DWN	APVD	SCALE	SIZE	DRAWING NO	SHEET	OF	REV	
						1:1	A1	1852892	3	of	3	A

DWN: M.YOUNGER 05OCT2012 MATERIAL: HEAT TREAT: -  
 CHR: T. ELBIN 05OCT2012  
 APVD: T. ELBIN 05OCT2012  
 NAME: T. ELBIN  
 ULTRA POD FLAG APPLICATOR



CUSTOMER ACCESSIBLE PRODUCTION DRAWING